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Aug 21, 2001

PUB-NO: JP02001225356A
DOCUMENT-IDENTIFIER: JP 2001225356 A
TITLE: COMPOSITE INJECTION MOLDING METHOD

PUBN-DATE: August 21, 2001

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APPL-NO: JP2000367378

APPL-DATE: December 1, 2000

INT-CL (IPC): B29 C 45/16; B29 C 45/26; B29 C 45/33

ABSTRACT:

PROBLEM TO BE SOLVED: To provide a composite injection molding method efficiently capable of injection molding at a low cost by one injection mold.

SOLUTION: A first sprue for a first resin communicating with a frame 1b through a first gate 11 and the second sprue for a second resin communicating with a frame 1e through a second gate are provided on a fixed side and a first slide piece 2 capable of advancing and retreating in a mold opening direction and the direction crossing the mold opening direction at a right angle and a second slide piece 3 capable of advancing and retreating only in the mold opening direction are arranged. A gate piece 23 enabling the second gate 21 to protrude is formed on a movable side 20 and constituted so as to close the second gate 21 at the time of advance of the first slide piece 2 and to communicate with the second gate 21 at the time of advance of the second slide piece 3 and the first resin is injected from the first sprue to primarily inject the base of a main body and the frame 7b lower than the base by one step and the second resin is injected from the second sprue to perform a series of operations up to secondary injection for filling the frame 1e lower than the base of the main body by one step in a mold closed state.

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